Work Order I February-11-14 3:22		028		*113	RN28*				<u>-</u>		Page 1
Item ID: D35 Revision ID: Item Name: Space	512-3 eer			Accept "	*N900	<u>040</u>	100)* s	Setup Star	17	S1* S2*
Start Date: 2/10 Required Date: 2/10 Reference:		Start Qty: 12.00 Req'd Qty: 12.00	1.7	ļ	Cust Item l Customer:	D:					
	·	MLJ	• • •	Tooling:		ate:		F	Star Stop	"I\I	R1* R2*
Sequence ID/ Work Center ID		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio	on Nbr									
D3512	D			i							
*100 *100* Waterjet FLOW CNC Waterjet	F	Dwg Rev:_ Prog Rev:_		0.00				16		19-	3 <u>-9</u>
110 *1 1 	Q	C2- Inspect parts off	machine FAI/FAIB	0.00				18		9 14	
¹²⁰ *1 2∩* QC	Q	PC8- Inspect parts - sec Memo	cond check	0.00 PAS 27 9-89 14/3	10			16			·.

Quality Control

DQA:			Date:			· <u>-</u>								TRAG ²
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / U		/ork Order up	odate only	\neg	AEROSPACE
•						DISPOSITION					EPARTMENT	. ,		
Work Orde	er: .	==				<u></u>	,			_	¬ · · · · · · · · · · · · · · · · · · ·	_	_	
Part N	۱o. ِ					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.		Engineering Quality
NCR N	۱o. ِ					Use-as-is Suspected Unapproved]	Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier		Other
Root					Desc	ription of work order update	Π	nitial	Act	tion	Sign &		1	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	·	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator									,					
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved														
							FA	ULT CAT	regory			-		
Landi	ng G	Gear				General		_			_	_		
		Bending				Bend		Folio/P	rogram	Ĺ	Outside Dim	ensions	Pr	ressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	tolerance	S	et-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	cí [⊤€	emperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/Mi	ssing	\w	/eld
		Cuffs				Contamination		Instruct	ions Incomplete/	Unclear	Part Moved	Ĺ	\w	rong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	0	ther
		Inspectio	n Strip in	Tube		Drawing		Misread	d					
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of 0	Calibration					
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of S	Sequence					

Work Ord February-11-14				*119	3028*					Page 2
Item ID: Revision ID: Item Name:	D3512-3 Spacer			Accept	*N900	004010	n* s	Setup Start Stop		S1* S2*
Start Date: Required Date: Reference:	2/10/14	Start Qty: 12.00 Req'd Qty: 12.00	*1 <i>2</i> * *1 <i>2</i> *	 	Cust Item :	ID:			TV.	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:	R	tun Start Stop	^IVI	R1* R2*
Sequence ID/ Work Center II 130 *120* Brake NC Brake NC	D	Operation Description Form as per dwg NC BRAKE Memo		Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code DAS 30 9-89	Accept Qty		Reject Number	Insp. Stamp (U 3 12
140 *140* QC Quality Control		QC5- Inspect part comple Memo	eteness to step on W/O	0.00 27 0.00 489 0.00 143	l)		16			
150 *150* Packaging Packaging		Identify as per dwg & Sto	ock Location: <u>W&O6</u> i	0.00			(16)	n	<u> </u>	<u> 14.04</u> .10

DQA:		D	ate: _							•				TRACT
		_				WORK ORDER NON-	-CC	ONFO	RMANCE / U				_	AEROSPACE
QA Closed:		D	ate:								Work	Order up	date only	
Work Orde	er:				•	DISPOSITION				AGAINST	DEPAI	RTMENT	PROCESS	
						Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	10.					Scrap			Machining	Small Fab	7	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging	Other
NCR N	10					Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Descr	iption of work order update		nitial	Act	tion		Sign &	····	
Cause	Da	te S1	tep	Qty		or non-conformance	Ch	ief Eng	Desc	ription	i	Date	Verification	QC Inspector
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Supplier	_				•						İ			
Training														
Transport			I			,								
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Landir	ng Gear					General	_	1 ,_		г	 -		<u></u>	
	Bend	-				Bend	<u> </u>	•	rogram	-	_	tside Dime	<u> </u>	Pressure/Forced
Ì	\dashv	e Not Co	oncen	tric		BOM/Route	<u> </u>	Grain		}		er/Under		Set-up
ŀ	Crack		·*	/\ \ \ \		Broken/Damage/Defect		Hardwa			_	rt Incorrec	 	Temperature/Cure
		o/Kink/R	ipple/	wave	—	Burrs	\vdash	i '	on Incomplete/U	· ·	_	rt Lost/Mi	· · ·	Weld
ŀ	Cuffs					Contamination		1	ions Incomplete/I	Unclear		rt Moved	_	Wrong Stock Pulled
Ì	Crush	iing Treat			_	Countersink Cut Too Short	\vdash	1 .	ned/off center	}		sitioned W	_	Jan
ŀ		ction Str	rin in '	Tuho	-	Drawing	\vdash	Mislabe Misread		Ĺ	PO'	wer Loss/S	ourge	Other
		s/Chatte	•	iube		Drill Holes	\vdash	Off-set	I					
		ng Sequ				Finish	<u> </u>	1	Calibration					
		:/Twist ii		e		Fit/Function	-	1	Sequence					
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Work Ord February-11-1		· -		*113	3028*							Page 3
Item ID: Revision ID: Item Name:	D3512-3 Spacer			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	2/10/14 e: 2/10/14	Start Qty: 12.00 Req'd Qty: 12.00	*1 <i>2</i> * *1 <i>2</i> *		Cust Item I Customer:	D:						
Approvals:	Process P	lan:	Date:	Tooling: _		te:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	ot Rej Qty		Reject Number	Insp. Stamp
1 6 0 QC		QC21- Final Inspection -	Work Order Release	0.00					14	14.	100	1

Memo

Quality Control

DQA:			Date:											TRAGE	•
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UI	PDATE	Wo	ork Order up	odate only	AEROSPACE	
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part N	 lo					Rework Scrap Use-as-is Suspected Unapproved		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		•	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root		1		·	Doses	intion of work and a wadet		la isia l		•			,		4
Cause		Date	Step	Qty	Desci	iption of work order update or non-conformance	l	Initial nief Eng	Act	ion iption		Sign & Date	Verification	OC Imamantan	
Design		,acc	эсер	- City		of fion-comormance		ilei Elig	Desci	ірноп		Date	verilication	QC Inspector	┨
Doc/Data	\dashv														
Equip/Tooling	\dashv													*	
Handling/Pre	_	1													
Material		1]			l
Operator												!			l
Offset/Setup															l
Process															l
Supplier													•	·	۱
Training						•						,			
Transport												,			1
Unapproved															
							FAI	ULT CA	EGORY				······································		1
Landir	ng Gea	r				General				<u>"</u> .					1
	Bei	nding				Bend		Folio/F	rogram			Outside Dim	ensions	Pressure/Forced	
	Cei	ntre Not	Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up	
	Cra	icks				Broken/Damage/Defect		Hardwa	re			Part Incorred	ci 「	Temperature/Cure	1
	Cri	mp/Kinl	c/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	Weld	
	Cu	ffs				Contamination		Instruct	ions Incomplete/U	Inclear		Part Moved		Wrong Stock Pulled	l
	Cru	ıshing				Countersink		Misalig	ned/off center			Positioned W			
	He	at Treat				Cut Too Short		Mislabe	eled			Power Loss/:	Surge	Other	
•	lns	pection	Strip in	Tube		Drawing		Misread	d]
	Ма	rks/Cha	itter			Drill Holes		Off-set							
	Tui	ning Se	quence			Finish		Out of	Calibration						1
	Wa	ve/Twis	st in Tub	e		Fit/Function		Out of	Sequence						1

Picklist Print

February-11-14 3:22:33 PM

Work Order ID: 113028

113028

Parent Item:

D3512-3

D3512-3

Parent Item Name: Spacer

Start Date: 2/10/14

Required Date: 2/10/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM

IPP

REV:B 13.12.11 ECN13-619/ REV.D DWG DD VERF.JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No	i	100	sf	111.7500	0.0943	1.191158			
M304S18	RGA			i				**	P	14.	2-9	

304/316 .050 Sheet

Location	Loc Oty	Loc Code	
MAT019	97.75		
117188	3		
117766	5	•	
120604	5		-
122325	3		
123155	3		
124572	38		
M126647	40.75		
MAT020	14		
124029	2		
M126098	12		

M128854 y 2.25

DQA:		Date:			WORK ORDER MON	~	ANEO!	3848BICE / 11	IDDATE				DART
QA Closed:		Date:			WORK ORDER NON	-((JNFO	RIVIANCE / U		Wc	ork Order up	date only	AEROSPACE
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Part N NCR N	lo.				Rework Scrap Use-as-is Suspected Unapproved	Scrap Machining Small Fab Prod. Eng. Coor. Use-as-is Thermoforming Finishing Rec/Store/Packaging Large Fab Composite Supplier					re/Packaging	Engineering Quality Other	
Root			1	Desci	ription of work order update	I	nitial	Ac	tion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
						FAI	ULT CAT	EGORY	***				
Landin	Bending Centre N Cracks Crimp/Ki Cuffs Crushing Heat Tree Inspectio Marks/Cl	at n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/U ions Incomplete/ ned/off center led	· •		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
Ţ	Wave/Tv	vist in Tub)e		Fit/Function		Out of s	Seguence		•			

DART AEROSPACE LTD	Work Order:	113028
Description: Wearplate Shim	Part Number:	03512-3
Inspection Dwg: 03572 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.09	4- 6.030	2.092	/		U JKMOS	
6.50	t/- 0.03d	6.502	/			
0.356	+/- 0.010	0.353	/			
2.75	t/r 0.030	2.75	/			
5.15	1/- 0.030	5.146	~			
6.100	t/- 0.010	0.103	V			
1.00	t/- 0-010	1.010				
		×				
			DAS			

			27			
Measured by:	R	Audited by:	9-89	F	Preliminary Approval:	
Date:	14-3-9	Date:	14/3/10		Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

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